



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3560-1
Job Sheet 173045



Part No: D3560-1

Job Qty: 4 ea

Part Name: Arm



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/26/18

Job Tracking No:

Due Date: 3/6/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV D IPP REV:A 13.06.03 PER DWG REV.D DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	3/5/18	3/5/18	0.00	0.00	Start Up Machining-2		DAS 18/03/18
100	Bandsaw	4 pcs	3/5/18	3/5/18	0.00	0.00	Bandsaw1		52 18/03/18
110	CNC Vertical Machining	4 pcs	3/5/18	3/5/18	0.61	2.76	HAAS1-3		9-89 18/03/18
120	QC	4 pcs	3/5/18	3/5/18	0.00	0.00	QC2 Machining-2		18/03/18
122	Mill Conv	4 pcs	3/6/18	3/6/18	0.00	0.41	Mill Conv 1		J.C.L. 18-03-21
124	QC	4 pcs	3/6/18	3/6/18	0.00	0.00	QC2 Machining-2		21 18-03-26
130	QC	4 pcs	3/6/18	3/6/18	0.00	0.00	QC8 Machining-2		21 18-03-26
210	Packaging	4 pcs	3/6/18	3/6/18	0.00	0.00	Packaging3-1	WA003	21 18-03-26
220	QC21-SA	4 Ea	3/6/18	3/6/18	0.00	0.00	QC21		21 18-03-26

Part Op 100 - Cut blanks 16.750" long

Descriptions: 110 - 1- Mill as per Folio FA693 Rev: _____ & Dwg D3560 Rev: _____ 2-C'sink 0.196" hole on manual mill as per dwg

D3560 3-Deburr per dwg D3560

210 - LOCATION: WA003

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.500X05.000	6061-T6 Bar .500 X 5.00	5.5800 ft (1.395 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.500X05.000	6	42	0

Part Specifications

Specifications could not be found.

Plex 2/26/18 7:39 AM dart.lacelle.linda

5047294
5052471

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid _____ Mac _____ Thermofo _____ Larg _____			Engineering ☐ Quality ☐ Other ☐																																																																													
Date : _____		Step #: _____		QTY _____			42) Approval																																																																													
Description Work Order Deviation					leted By _____ / Supervisor Verification _____ Coordinator approval _____																																																																															
<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th colspan="4" style="text-align: left; padding: 5px;">Root Cause</th> </tr> <tr> <td style="width:15%; padding: 5px;">Environment ☐</td> <td style="width:15%; padding: 5px;">☐</td> <td style="width:15%; padding: 5px;">No Re-verification ☐</td> <td style="width:15%; padding: 5px;">Pressure/Forced ☐</td> <td style="width:15%; padding: 5px;">☐</td> <td style="width:15%; padding: 5px;">Temperatur ☐</td> <td colspan="3" rowspan="12" style="text-align: center; vertical-align: middle;"> Date: 03/18/18 Inspector: _____ Revision: _____ Serial No/Batch: S052472 Job No: 173045 Part: D3560-1 Container No: S052472 DART AEROSPACE </td> </tr> <tr><td style="padding: 5px;">Design ☐</td><td style="padding: 5px;">☐</td><td style="padding: 5px;">Operator ☐</td><td style="padding: 5px;">Bending ☐</td><td style="padding: 5px;">☐</td><td style="padding: 5px;">Set-up ☐</td></tr> <tr><td style="padding: 5px;">Doc/Data ☐</td><td style="padding: 5px;">☐</td><td style="padding: 5px;">Offset/Setup ☐</td><td style="padding: 5px;">Centre Not Concentric ☐</td><td style="padding: 5px;">☐</td><td style="padding: 5px;">BOM/Route ☐</td></tr> <tr><td style="padding: 5px;">Equip/Tooling ☐</td><td style="padding: 5px;">☐</td><td style="padding: 5px;">Supplier ☐</td><td style="padding: 5px;">Cracks ☐</td><td style="padding: 5px;">☐</td><td style="padding: 5px;">Broken/Dan ☐</td></tr> <tr><td style="padding: 5px;">Handling/Pre ☐</td><td style="padding: 5px;">☐</td><td style="padding: 5px;">Training ☐</td><td style="padding: 5px;">Crimp/Kink/Ripple/Wave ☐</td><td style="padding: 5px;">☐</td><td style="padding: 5px;">Inspection li ☐</td></tr> <tr><td style="padding: 5px;">Material ☐</td><td style="padding: 5px;">☐</td><td style="padding: 5px;">Use for Testing ☐</td><td style="padding: 5px;">Cuffs ☐</td><td style="padding: 5px;">☐</td><td style="padding: 5px;">Contaminat ☐</td></tr> <tr><td style="padding: 5px;">Internal Transport ☐</td><td style="padding: 5px;">☐</td><td style="padding: 5px;">Poor Information ☐</td><td style="padding: 5px;">Crushing ☐</td><td style="padding: 5px;">☐</td><td style="padding: 5px;">Countersink ☐</td></tr> <tr><td style="padding: 5px;">Tribal Knowledge ☐</td><td style="padding: 5px;">☐</td><td style="padding: 5px;">Rushing ☐</td><td style="padding: 5px;">Heat Treat ☐</td><td style="padding: 5px;">☐</td><td style="padding: 5px;">Cut Too Sho ☐</td></tr> <tr><td style="padding: 5px;">LOA ☐</td><td style="padding: 5px;">☐</td><td style="padding: 5px;">Product Improvement ☐</td><td style="padding: 5px;">Wave/Twist in Tube ☐</td><td style="padding: 5px;">☐</td><td style="padding: 5px;">Instructions ☐</td></tr> <tr><td style="padding: 5px;">Substation ☐</td><td style="padding: 5px;">☐</td><td style="padding: 5px;">Process Improvement ☐</td><td style="padding: 5px;">Marks/Chatter ☐</td><td style="padding: 5px;">☐</td><td style="padding: 5px;">Drill Holes ☐</td></tr> <tr><td style="padding: 5px;">Past Expiry Date ☐</td><td style="padding: 5px;">☐</td><td style="padding: 5px;">Manufacturing Process ☐</td><td colspan="3" rowspan="2" style="vertical-align: top;">OTHER : _____</td></tr> <tr><td style="padding: 5px;">Misidentified ☐</td><td style="padding: 5px;">☐</td><td style="padding: 5px;">Past Due ☐</td></tr> </table>									Root Cause				Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	☐	Temperatur ☐	Date: 03/18/18 Inspector: _____ Revision: _____ Serial No/Batch: S052472 Job No: 173045 Part: D3560-1 Container No: S052472 DART AEROSPACE			Design ☐	☐	Operator ☐	Bending ☐	☐	Set-up ☐	Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	☐	BOM/Route ☐	Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	☐	Broken/Dan ☐	Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection li ☐	Material ☐	☐	Use for Testing ☐	Cuffs ☐	☐	Contaminat ☐	Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	☐	Countersink ☐	Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	☐	Cut Too Sho ☐	LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	☐	Instructions ☐	Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	☐	Drill Holes ☐	Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____			Misidentified ☐	☐	Past Due ☐
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DART AEROSPACE LTD		Work Order: 173045
Description: Arm		Part Number: D3560-1
Inspection Dwg: D3560	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	Ø.506				
Ø0.196	+0.005/-0.001	Ø.196				
Ø1.000	+0.010/-0.001	Ø1.002				
0.500	+/-0.010	.496				
0.250	+/-0.010	.250				
0.275	+/-0.010	0.275				
0.188	+/-0.010	0.188				
2.000	+/-0.010	2.000				
1.700	+/-0.010	1.700				
Ø0.385 x 100°	+/-0.010 x 0.5°	0.390	✓		Caliper	3CL-08
0.250 Deep	+/-0.010	.253				

Measured by: DAS 52/3.C.L.	Audited by: DAS 20 9-89	Prototype Approval: N/A
Date: 18-03-17/18-03-24	Date: 18-03-26	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue P/O D3560-041	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	
C	08.07.24	Dwg Rev updated	KJ/DD	